

SEM[®] PLASTIC REPAIR

STANDARD OPERATING PROCEDURE

1 PREP



Clean front and back with **Scuff & Clean** and gray scuff pad. Rinse with water and dry with clean, lint-free cloth. Clean front and back with **SEM Solve, Plastic & Leather Prep** or **Zero VOC Surface Cleaner**. Wipe clean in one direction with dry, lint-free cloth.

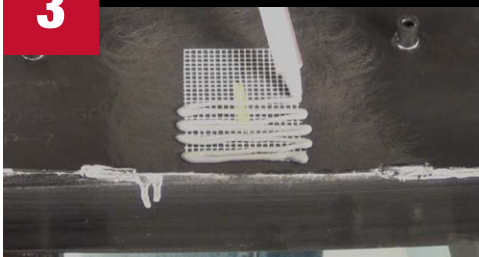
2 SAND & GROOVE



On front side, sand repair area with P80 grit. Dish out damage with 36 grit disc at a low RPM. On back side, grind repair area with 36 grit disc at a low RPM. Blow off surfaces.

- ⓘ Paint does not need to be stripped from the repair if it has good adhesion.
- ⚠ Do not grind too fast and cause plastic to melt.

3 REINFORCE & FILL BACK



Mask front side of repair to prevent repair material from flowing through. Apply **Plastic Repair Contouring Tape** (mesh only) to back side. Apply **Dual-Mix™ Multi-Plastic Repair Material** or **Dual-Mix Problem Plastic Repair Material** and cover mesh tape. Spread material firmly. Allow to set.

4 REINFORCE & FILL FRONT



Remove tape from front. Fill front with **Dual-Mix Multi-Plastic Repair Material** or **Dual-Mix Problem Plastic Repair Material**. Spread material firmly and build up higher than panel to allow for sanding.

5 SAND & SKIM



Sand with P80 grit. Finish with P180 grit. If needed, use a skim coat of **Bumper Bite™ Flexible Glaze**, then sand with P180 – P320 grit.

- ⓘ Refer to **Plastic Refinishing SOP** for refinishing steps.

WATCH & LEARN



WATCH THE VIDEO AT:
semproducts.com/sop-plastic-repair

PRODUCT LIST



PREP

Part	Product	Size
38391	Scuff & Clean	Gallon Pump
38398	Scuff & Clean	16 oz. Tube
38371	SEM Solve	Gallon
38373	SEM Solve	20 oz. Aerosol
38374	SEM Solve	Square Quart
38351	Plastic & Leather Prep	Gallon
38353	Plastic & Leather Prep	16 oz. Aerosol
38354	Plastic & Leather Prep	Cone Top Quart
40401	Zero VOC Surface Cleaner	Gallon
40404	Zero VOC Surface Cleaner	Quart



REINFORCE AND FILL

Part	Product	Size
70007	Plastic Repair Contouring Tape	15' Roll
39767	Dual-Mix Problem Plastic Repair Material	7 oz. Cartridge
39847	Dual-Mix Multi-Plastic Repair Material	7 oz. Cartridge



SAND AND SKIM

Part	Product	Size
40482	Bumper Bite Flexible Glaze	16 oz. Tube

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